

Work Order ID 106533

Friday, September 06, 2013 10:35:05 AM

106533

UPDATE
IN OFFICE

Page 1

Item ID: D350-636-216

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Deluxe Skidtube RH Aerazur / Apical Cylindrical Float Compatible

Stop *NS2*

Start Date: 9/5/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/13/2013 Req'd Qty: 1.00

1

Customer:

Reference: ECN 13-535

Approvals: Process Plan: MF Date: 13-9-6

Tooling:

Date:

Run Start *NR1*

QC: Date:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-636	J

170 0.00

170

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D350-636-216 X 1 B85193

106534

REMOVE OLD PAPERWORK AND REPLACE WITH NEW

ADD 1 X D3456-1 TO KIT AND UPDATE TO CHANGE 005

ID AND STOCK UNDER NEW BATCH NUMBER

Ed Kli 9/12/13

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

Work Order ID 106533

Friday, September 06, 2013 10:35:05 AM

106533UPDATE
IN OFFICE

Page 1

Item ID: D350-636-216

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Deluxe Skidtube RH Aerazur / Apical Cylindrical Float Compatible

Stop

NS2

Start Date: 9/5/2013 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/13/2013 Req'd Qty: 1.00

1

Customer:

Reference: ECN 13-535

Approvals: Process Plan: MFDate: 13-9-6

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D350-636

J

170

0.00

170

Packaging

Memo

0.00

Packaging

PULL FROM STOCK D350-636-216 X 1 B85193

REMOVE OLD PAPERWORK AND REPLACE WITH NEW

ADD 1 X D3456-1 TO KIT AND UPDATE TO CHANGE 005

ID AND STOCK UNDER NEW BATCH NUMBER

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	---	---

Work Order ID 106533

106533

Page 2

Friday, September 06, 2013 10:35:05 AM

Item ID: D350-636-216 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Deluxe Skidtube RH Aerazur / Apical Cylindrical Float Compatible
 Start Date: 9/5/2013 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 9/13/2013 Req'd Qty: 1.00 *1* Customer:
 Reference: ECN 13-535

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

update
offshore
MF
13-9-18

MLJ 13-09-18

MF
13-9-18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other		

REVISION RECORD

Revision	Issue Date	Description
A	98.04.16	New Issue
B	98.09.02	Change blade bolt to AN8-16A
C	98.11.19	Add -013/-014 skid tubes for Aircruiser compatibility
D	06.01.03	Add compatibility with Apical Tri-bag Floats and Apical Cylindrical Floats
E	07.05.15	Change wearplates to stainless steel; Re-organize installation procedure.....pg. 4-7; Add Dart D350-748 crosstube compatibility.....pg. 3; Incorporate DSI 9343.....pg. 6,13; Replace D350-636-041 kit with -043 kit.....pg. 12,13; Item 17 now D3631-1 Washer.....pg. 12; Item 18 now ALS4-1032-225.....pg. 12; Removed * from items 9-12.....pg. 12; Add rubber gaskets, item 23B, 24B, 25B.....pg. 13; Remove NAS1515H3L washers from the wearshoes.....pg. 13
F	08.08.14	Add note to use Antiseize compound.....pg. 5, 8; Add reference to DSI 9413;.....pg. 6-7; Add D350-636-011/-012/-013/-014 at CHG 004 drawing.....pg. 10; Add Parts List for D350-636-011/-012/-013/-014 at CHG 004.....pg. 17
G	10.07.12	Incorporated DSI 9456, DSI 9457, DSI 9490 Fixed typo on pg. 3, 355A41-2002-03 changed to 355A41-2001-03
H	10.07.26	Add D350-636-015/-016/-017/-018/-047 kits.....pg. 13; Add Parts List for D350-636-015/-016/-017/-018/-047.....pg. 29; Add D350-636-215/-216/-217/-218 Kits.....pg. 13; Add Parts List for D350-636-215/-216/-217/-218.....pg. 31
I	10.10.25	D4170-3 Spacer was D4170-1pg. 10,30; Drill size for D4170-3 Spacer is Ø0.453" (was Ø0.313 for -1)....pg. 10
J	13.03.01	Incorporate DSI 9570.....pg. 3; Ø0.633" was Ø0.625" section 3.10.1.....pg.10; Revised section R-Rpg. 17; Update Weight and Balance for D350-636-047.....pg. 22; Add 1X D3456-1 to D350-636-109.....pg. 28

• COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. •
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR
COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

Revision: J

Date: 13.03.01

List Lots

September-05-13 11:19:21 AM

Page 1 of 1

Criteria : Item ID: 'D350-636-215', 'D350-636-216', 'D350-636-217', 'D350-636-218'

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	All Locations	All Warehouses	All Quantity	Type Code	Comments
D350-636-215 Deluxe Skidtube LH Aerazur / Apical Cylindrical Float Compatible										
	Main Warehouse FG	91248 #106529	6/05/13	1.0000		QC21		CHG004		Angle of 1.44*
	Main Warehouse FG072	97328 #106525	5/10/13	1.0000		QC21		CHG004		Angle of 2.73* . Ship Local
	OFFSHORE FG	85190 #106529	5/22/13	1.0000		QC21		CHG004		
	OFFSHORE FG	91245 #106530	5/10/13	1.0000		QC21		CHG004		
	OFFSHORE FG	91246 #106531	6/05/13	1.0000		QC21		CHG004		
		Total:		5.0000						
D350-636-216 Deluxe Skidtube RH Aerazur / Apical Cylindrical Float Compatible										
	Main Warehouse FG073	91252 #106532	5/10/13	1.0000		QC21		CHG004		Angle of 2.56* . Ship local
	OFFSHORE FG	85193 #106533	5/22/13	1.0000		QC21		CHG004		
	OFFSHORE FG	91249 #106534	5/10/13	1.0000		QC21		CHG004		
	OFFSHORE FG	91250 #106535	6/05/13	1.0000		QC21		CHG004		
		Total:		4.0000						
D350-636-218 Deluxe Skidtube RH Air Cruiser / Apical Tri-Bag Float Compatible										
	Main Warehouse FG073	91253 #106536	5/10/13	1.0000		QC21		CHG004		Angle of 1.98*
		Total:		1.0000						

101114
50-189-07